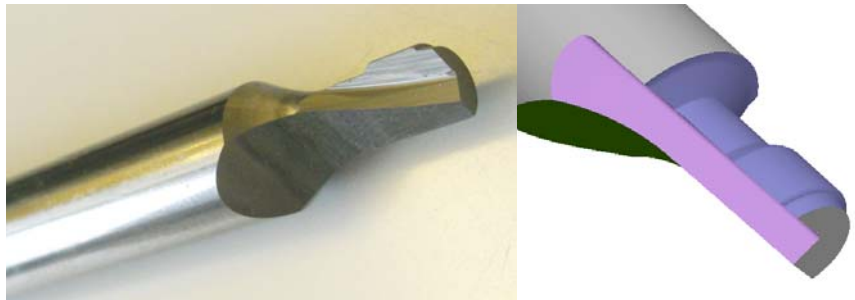


ID-Turning Tool Ø10 Z1

A17-010














The profile of ID-Turning Tools can be ground using either the surface type CS 1 CAM or CS 1 CYL from DXQ Profilegrinding option. The advantage of CS 1 CAM: Turning tools with additional clearance angles can be ground.



1. Cycletime for production

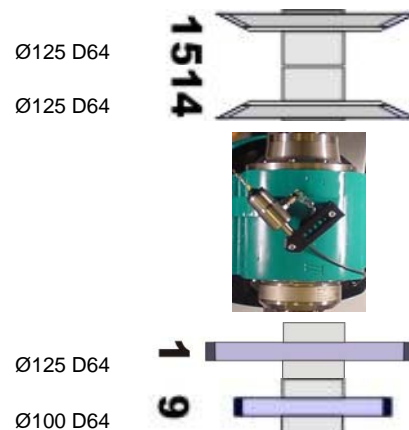
Toolspecifications

Diameter 10 mm, Cutting edges 1, Length of cutting edge 12 mm, Helix angle 0.001 deg
Material HM

Operations							
	Probe	Flute 1	Flute 2	Prf Rough	Prf Pregr	Prf Cyl	Red. from shank
Feed [mm/Min]	2000	60	100	30	40	3	100
Power [kW]		4	2	2	1	1	1
Cutting feed [m/s]		18	18	22	24	22	24
Used wheels							
Grinding time [s]	14	31	22	162	114	360	44
Total cycle time	12 Min 27						

The mentioned cycle times are indicative. The material to be ground, other grinding wheels and other coolants can influence the cycle times considerably.

2. Used grinding wheels



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, NORMA CFG
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5

responsible engineer: O.Pellegrini,22.01.07

www.schneeberger.ch

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TECHNOLOGY
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